

Date: Friday, 9/14/2007 2:02:03 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	CROSSTUBE EXTRUSION (412 AFT)		
Job Number	34691			Part Number	D6009129		
Estimate Number	10030			Drawing Number	D6009 REV A		
P.O. Number				Project Number	N/A		
This Issue	9/14/2007	S.O. No.		Drawing Revision	A		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	LANDING GEAR	Due Date	1/30/2008	Qty:	26
Previous Run	32306			Um:	Each		
Written By	<i>DD</i> 207109.17						
Checked & Approved By							
Comment	Est Rev A 01.08.17 New Issue SM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING

Comment: PURCHASING

Issue P/O: *46e11**Cd 7/09/18**(26)*

- a) Order as per Dwg D6009
- b) Material: 3.500 x 0.625 wall 7075-T6/T6511 (WW-T-700/7 or QQ-A-225/9 or QQ-A-200/11) seamless aluminum tube
- c) Minimum ultimate tensile strength = 77 ksi
- d) Minimum tensile yield strength = 66 ksi
- e) Tolerance are per ASTM B210 (see details on Dwg D6009)
- f) Material certification required

2.0 D6009129P Crosstube Material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 26.0000 Each(s)

Crosstube Material

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
 Ensure material certification is attached

1/31/11 (26)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D

1/08/03/12 +26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/31/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSTUBE EXTRUSION (412 AFT)

Job Number: 34691

Part Number: D6009129

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	HAND FINISHING	HAND FINISHING RESOURCE #1 <i>u4 08/03/13</i>
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1
6.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>SL 08.03.12 26</i>
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>L6</i>
7.0	QC21	FINAL INSPECTION/W/O RELEASE <i>26 08/03/13</i>
		Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



~ 2008/3/13

26

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

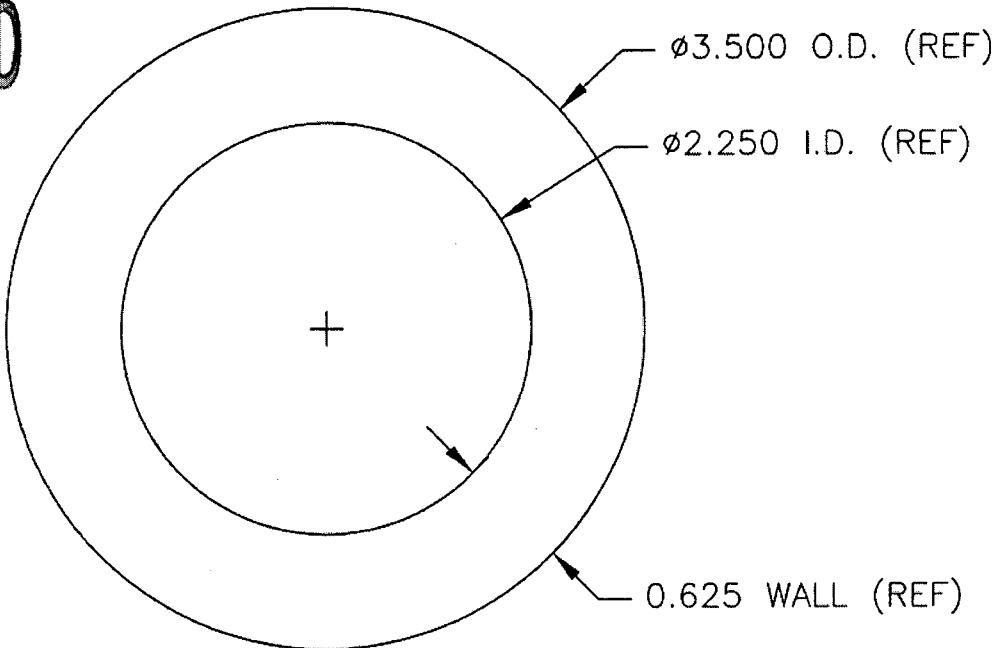


TOP SECRET
NOV 2000

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D6009	SHEET 1 OF 1
DATE	TITLE	SCALE	
01.08.16	CROSSTUBE MATERIAL	1:1	
A	01.08.16	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.08.17



NOTES

- 1) D6009-XXX CROSSTUBE

LENGTH

WHERE XXX IS LENGTH IN INCHES
EG. 129" LONG TUBE: D6009-129

- 2) MATERIAL: 3.500 OD x 0.625 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.
MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi
MINIMUM YIELD TENSILE STRENGTH = 66 ksi
- 3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:
O.D.: ± 0.008 MEAN (± 0.016 INCLUDING OVALITY)
WALL: ± 0.020 MEAN (± 0.063 INCLUDING ECCENTRICITY)
LENGTH: XXX $+0.188/-0.000$
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
- 4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
34691
NO



ALUnna Tubes Limited
Telephone 01527 484500 - Facsimile 01527 484501
www.alunnatubes.com

Approved Certificate According to EN10204:2004 3.1

For all Customer and 3rd Party approvals
visit www.alunnatubes.com

No. C/150332/1

Customer				Your Order No	PO00004611		Other Tests Passed											
DART AEROSPACE LIMITED 1270 ABERDEEN STREET HAWKESBURY ONTARIO CANADA K6A 1K7				Your Part No	D6009-129P													
				Our Order No	94945/7													
				Packing Note No	150332													
				Date	31/01/08													
				Packages	1 CASE													
Size / Description				Specification														
SEAMLESS EXT TUBE 3.5 INS O/D 0.625 INS W/T 7075 Alloy Length - 129.02 inches				7075 T6 QQ-A-200/11E														
No of Pieces	Nett Weight Lbs		Tensile Test					Chemical Analysis %									H cc/ 100 gm	
			Test No	0.2% Proof Stress KSI	Tensile Strength KSI	% Elongation 4 x Dia		Heat or Cast No	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Zr	
7	516	332044 LO	80.8	88.5	9		2N268	.07	.29	1.41	.03	2.39	.21	.01	5.79	.01	.03 .13	
4	295	332043 LO	79.6	87.6	9		2N268	.07	.29	1.41	.03	2.39	.21	.01	5.79	.01	.03 .13	
11	811	332288 LO	79.2	88.0	7		2N319	.08	.27	1.40	.04	2.39	.22	.01	5.73	.01	.02 .08	
4	295	332046 LO	81.8	86.9	7		2N268	.07	.29	1.41	.03	2.39	.21	.01	5.79	.01	.03 .13	

Remarks

ALLOY MELTED IN THE UNITED KINGDOM

Authorised Inspection Representative

Mr Terry Layton - For and on behalf of Alunna Tu

In accordance with the RoHS directive, ALUnna Tubes certify that the above mentioned product does not contain banned or relevant substances.

Mercury Free.

Registered in England No. 06448371

Registered Office : Studley Road, Redditch,
Worcestershire, B98 7HN, England

V.A.T. Registration No. GB 923 7112 44

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These results pertain only to the item(s) tested as samples by the client unless otherwise indicated.